

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018843**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT No: 7373

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as corner assembly. The weld designations are as follows:

CA3015-005

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG 13 EAST

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037705 performing the Flux Cored Arc Welding process on weld 004 located at PCMK SEG3007H. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068494 performing the Flux Cored Arc Welding process on weld 033 located at PCMK SEG3007J. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044790 performing the Flux Cored Arc Welding process on weld 248 located at PCMK SEG3007N. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 217805 performing the Flux Cored Arc Welding process on weld 197 located at PCMK SEG3007M. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 139 located at PCMK SEG3009H. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 099 located at PCMK SEG3009D. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing ultrasonic testing for the weld between longitudinal diaphragm and bottom panel. Weld number identified as SEG3009L-255.

OBG 14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 009 located at PCMK SEG3019A. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-fcm-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer